

Work Order ID 139277

Thursday, November 19, 2015 9:25:00 AM

139277

RUSH

Page 1

Item ID: D3849-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Run-On Landing Wearplate Fwd for Standard Skid tubes
 Start Date: 11/19/2015 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 11/27/2015 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: UMF Date: 15-11-19 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3849	E

110

0.00

110

Large Fab

Large Fab

Memo

0.01

1- On D3901-1 bar, fill cut outs with hardcoat welding rod as per dwg D3849

2059 B Hardcoat Welding Rod

BATCH#: M 126584 → 20596

2- Weld D3901-1 bar to wearplate as per dwg D3849

304 S.S. Welding Rod

BATCH #: M 123823

3- Transfer drill holes as per dwg

4- Cut excess bar material if necessary

1 NR 15-11-19

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00

120

QC

Quality Control

Memo

0.00

1 15-11-19

DAS

50

9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :							
Misidentified	☐	Past Due	☐								

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Page 3

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Revision ID: Stop ***NS2***
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Required Date: 11/27/2015 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>FP-60C</u>	0.00				<u>xi</u>	<u>d</u>	<u>22</u>	<u>11/16/20</u>
160									
Packaging	Memo	0.00							
Packaging	LOCATION : FP002								
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00				<u>MCS</u>		<u>15-11-20</u>	<u>10</u>
Quality Control									

SA 20151120

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter		☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes		☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center		☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence	
OTHER : _____											

Picklist Print

Thursday, November 19, 2015 9:25:00 AM

Page 1

Work Order ID: 139277

139277

Parent Item: D3849-041

D3849-041

Parent Item Name: Run-On Landing Wearplate Fwd for Standard Skidtubes

Start Date: 11/19/2015

Required Date: 11/27/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC
12.09.11 AS PER DWG REV.D DD VERF:JLM IPP Rev:B
AS PER DWG REV.E DD VERF:JLM IPP Rev:C 14.11.26

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3849-1		Manufactured	No			110	Each	9.0000	1	1			
D3849-1									**	<u>x1</u>	<u>212</u>	<u>15/11/19</u>	
Plate													

Location	Loc Qty	Loc Code
WA001	1	
119045	1	
WA002	8	
127091	4	
134557	4	

D3901-1		Manufactured	No			110	Each	8.0000	1	1			
D3901-1									**	<u>x1</u>	<u>212</u>	<u>15/11/19</u>	
Bar													

Location	Loc Qty	Loc Code
WA001	8	
129813	2	
133877	6	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

8

7

6

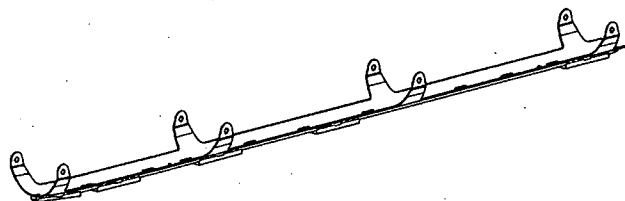
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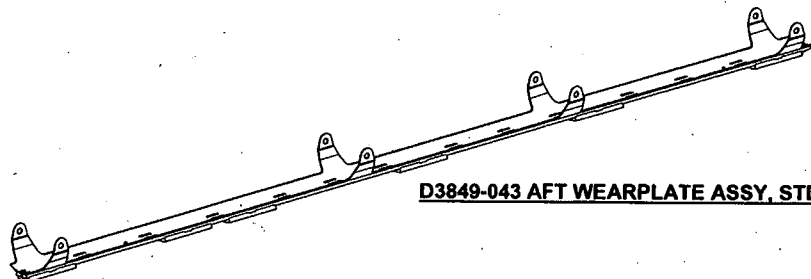
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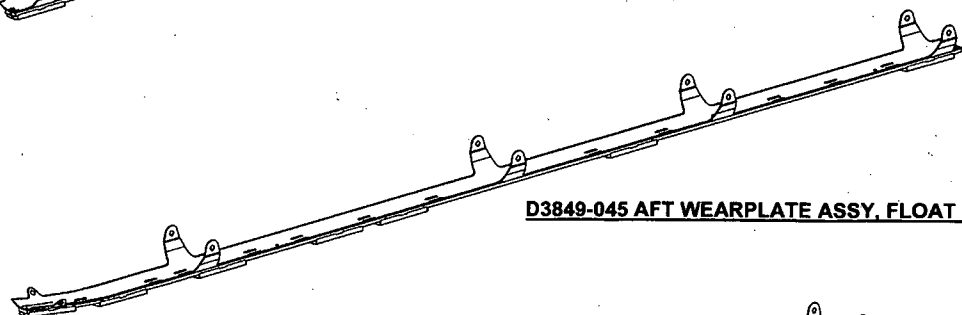
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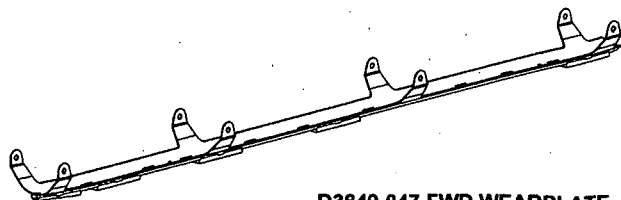
D3849-041 FWD WEARPLATE ASSY, STD GEAR



D3849-043 AFT WEARPLATE ASSY, STD GEAR



D3849-045 AFT WEARPLATE ASSY, FLOAT GEAR



D3849-047 FWD WEARPLATE, FLOAT GEAR

ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
1	X				D3849-041	FWD WEARPLATE ASSY, STD GEAR
2		X			D3849-043	AFT WEARPLATE ASSY, STD GEAR
3			X		D3849-045	AFT WEARPLATE ASSY, FLOAT GEAR
4				X	D3849-047	FWD WEARPLATE ASSY, FLOAT GEAR
11	1				D3849-1	PLATE
12		1			D3849-3	PLATE
13			1		D3849-5	PLATE
14				1	D3849-7	PLATE
15	1			1	D3901-1	BAR
16		2			D3901-3	BAR
17			2		D3901-5	BAR
21	A/R	A/R	A/R	A/R	2059B	HARDCOAT
22	A/R	A/R	A/R	A/R	TEXTURED COATING	SEALANT



139277

RELEASED

2014 NOV 24 4P
ECN 14-628

E	TEXTURED COATING WAS 4714 ROCKGUARD (BOM TABLE). CHANGE NOTE 10 (SH 2, 3, 4, 5). 8.49 LBS WAS 7.66 LBS (SH 3, NOTE 7). 10.25 LBS WAS 8.83 LBS (SH 4, NOTE 7). 4.66 LBS WAS 4.60 LBS (SH 5, NOTE 7).	AK	14.08.07
D	REVISED FLAT PATTERN - CHANGED SLOT LOCATIONS TO MATCH D3901-1/-3/-5 BARS (ZN B6-6, B3-6, B6-7, C2-7, B6-8, B2-8, B7-9, B2-9).	DC	12.08.23
C	REVISED FLAT PATTERN - CHANGE SLOT LOCATIONS. ADDED DOUBLE SLOTS AND D3901-3/-5 BARS ON -043/-045. UPDATED DETAIL VIEWS. CHANGED WELD DETAILS (ZN B2-2). REMOVED D3849-1/-3/-5/7 GASKETS. ADD ROCKGUARD COATING. REMOVE FINISH.	DC	12.08.21
B	REVISED FLAT PATTERN Ø0.375 WAS SLOT HOLE ON D3849-1F/-3F/-5F (ZN A4-5, B4-7, B4-8, C2-10, B2-10). ADD D3849-047 (ZN D4-1, A4-1 & B4-5) & D3849-7/-7F (ZN C4-9, A4-9). ADD SECTION K-K (ZN C5-10). 0.88 WAS 0.875 & 0.44 WAS 0.438 (ZN A3-10). ADD 0.25 & 0.88 (ZN D4-10, D3-10). ADD 0.88 & 0.44 (ZN C3-10 & B3-10). ADD FLAG NOTE (ZN A8-2, C6-2, C3-2, A8-3, C6-3, C3-3, A8-4, C6-4, C2-4). 66.87 WAS 67.36 (ZN B4-7).	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	AK		
CHECKED	VS	DRAWING NO.	REV. E
MFG. APPR.	DD	D3849	SHEET 1 OF 10
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	WEARPLATE ASSY	NTS
DATE	14.08.07	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

APPROVED

DQA: _____ Date: _____



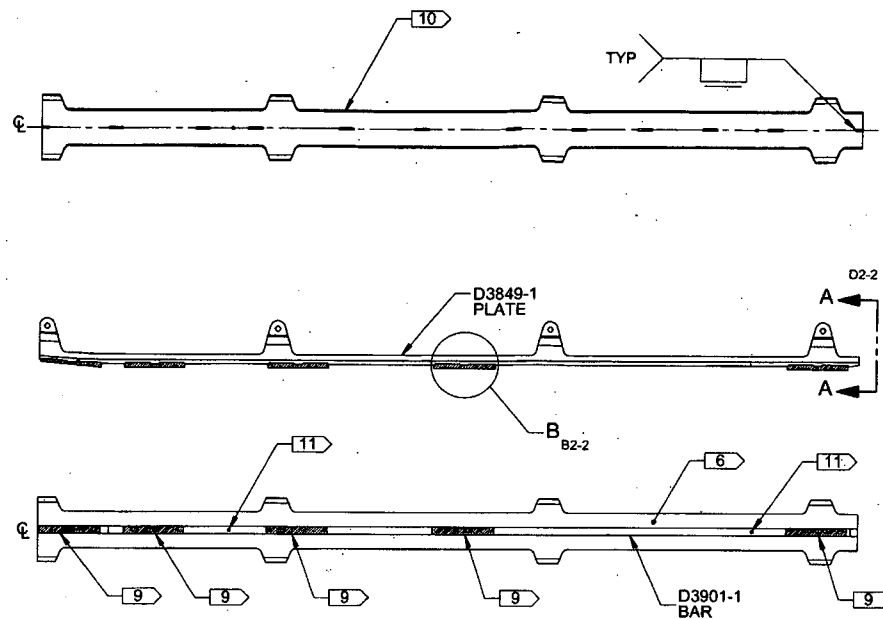
WORK ORDER NON-CONFORMANCE / UPDATE

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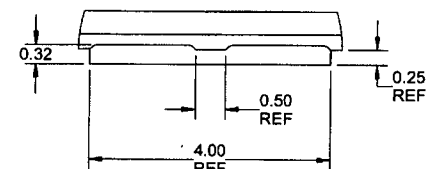
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Misidentified	☐	Past Due	☐								



SECTION A-A

C3-2



DETAIL B

C5-2

D3849-041 FWD WEARPLATE ASSY, STD/FLOAT GEAR

RELEASED

2014 NOV 24

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 AS SHOWN
- 7) WEIGHT: D3849-041 = 4.58 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.32 THICK x 0.50 WIDE, FLUSH WITH D3901-1 BAR ON LATERAL SURFACES
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020-0.040 THICK, PER DART QSI 005 4.9.
- 11) TRANSFER DRILL $\varnothing$ 0.188 HOLES FROM D3849-1 PLATE TO D3901-1 BAR

APPROVED

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	AK	KENT, WA	
CHECKED	VS	DRAWING NO.	REV. E
MFG. APPR.	DD	D3849	SHEET 2 OF 10
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	WEARPLATE ASSY	NTS
DATE	14.08.07	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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				OTHER :							